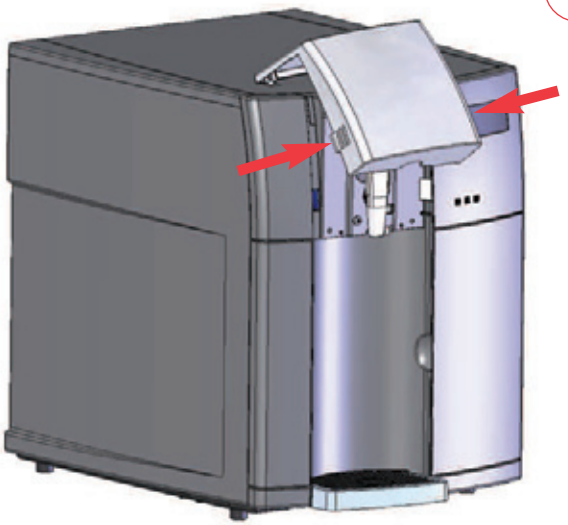
NATURAL CHOICE®

ION™
pure refreshment

# TECHNICAL SERVICE MANUAL

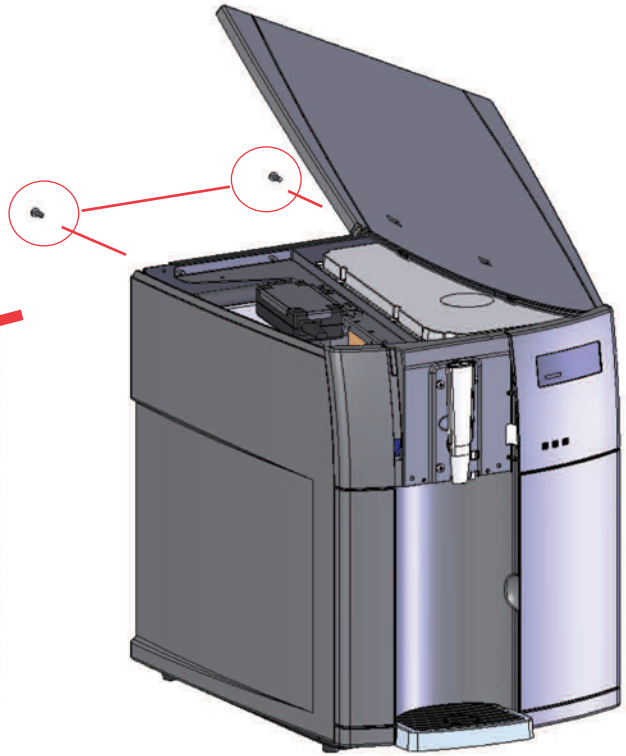
# Opening the Appliance

- **CAUTION:** Unplug from electrical outlet before servicing
- **IMPORTANT:** Torx 20 screwdriver required



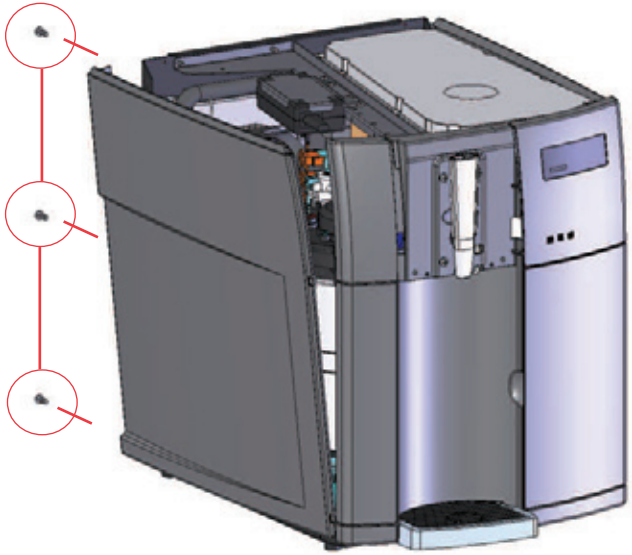
## Remove Faucet Cover

- Squeeze sides at arrows and lift



## Remove Top Panel

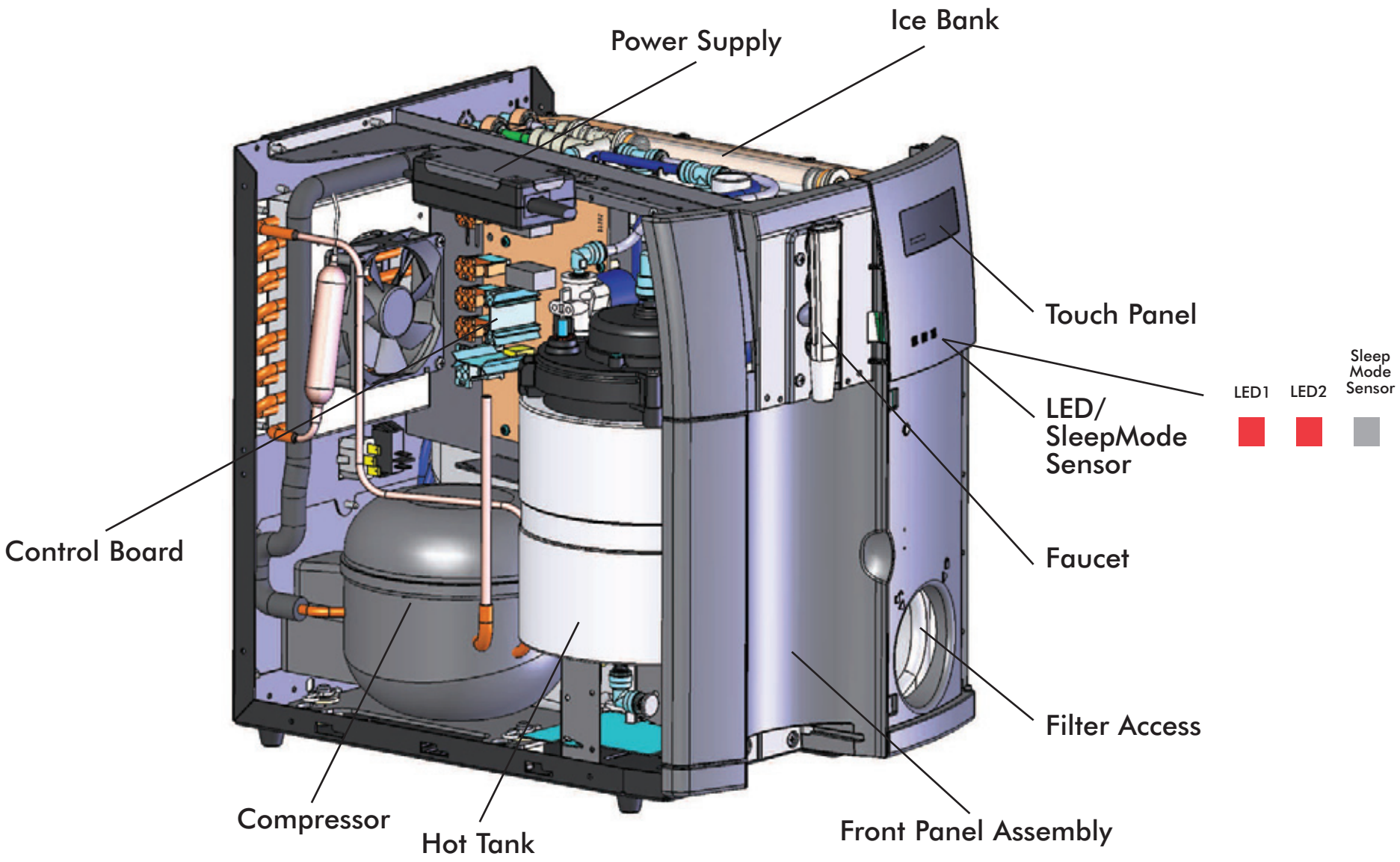
- Loosen 2 screws at top, rear
- Pull panel up at rear
- Then roll to right front corner



## Remove Left Side Panel

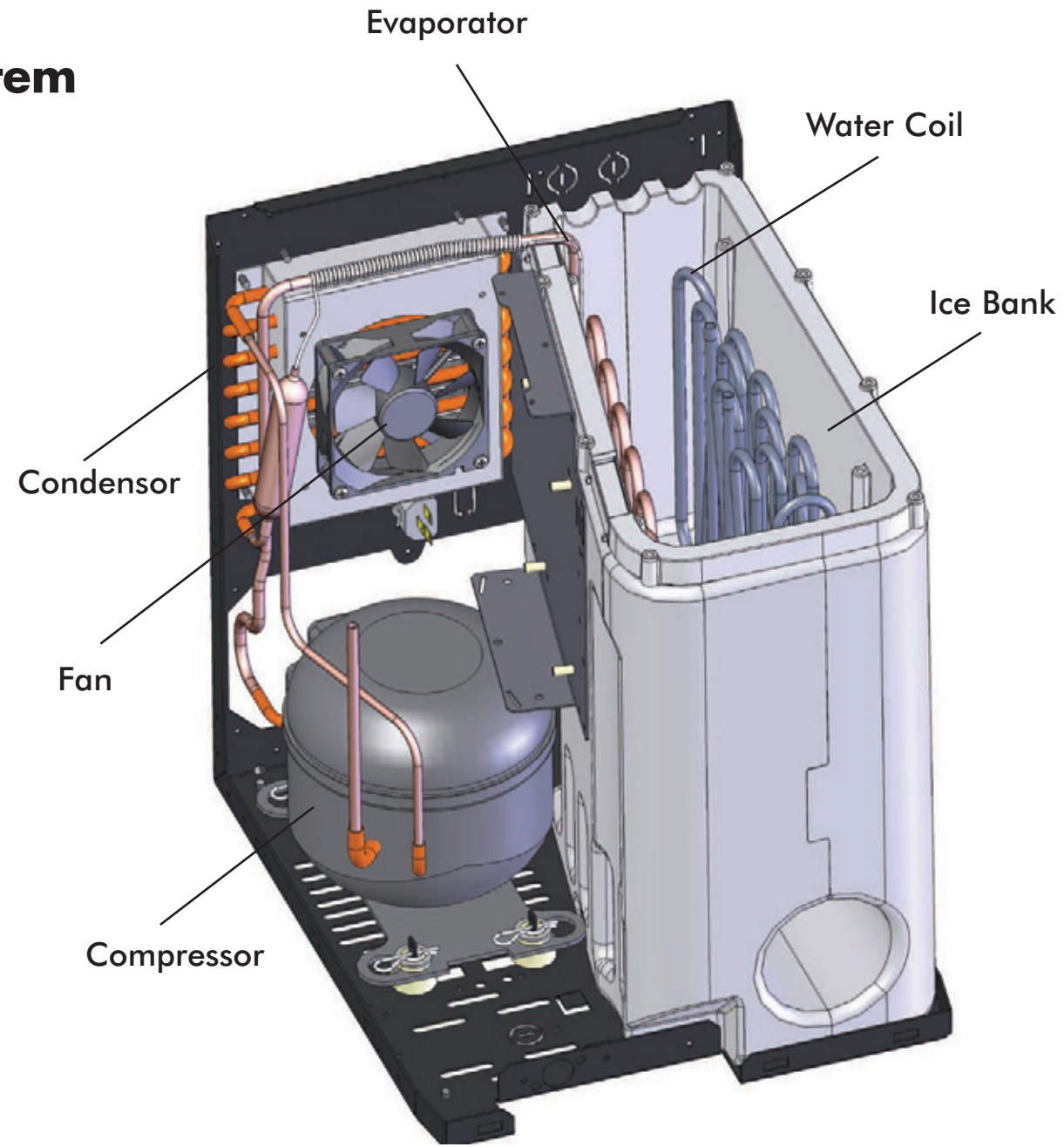
- Remove 3 screws left side
- Slide back 1 inch
- Tilt panel down to remove

# Major Components Service View



# InstaChill™ Cooling System

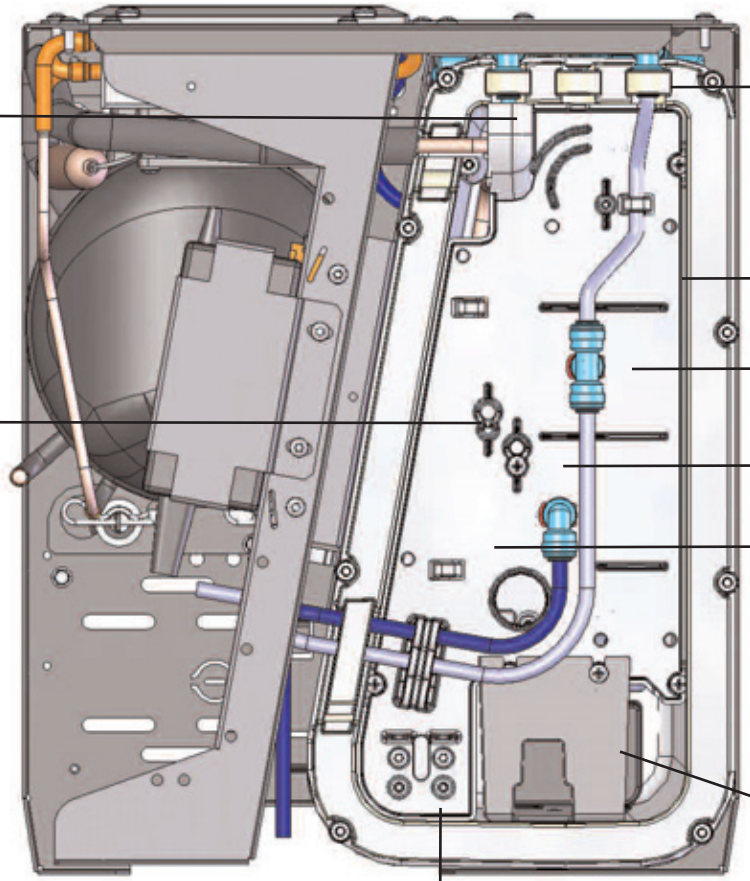
- Uses a 20′ length of 1/4″ OD Water Coil inside a Tank (called Ice Bank) filled with water and ice.
- No reservoir of drinking water.
- 3″ thick slab of ice is formed on left side of Ice Bank.
- Ice Bank Pump circulates water in the Ice Bank, chilling the drinking water inside the Water Coil.
- Ice Bank Pump is activated for 1 minute, every time Cold or Sparkling water is dispensed.
- Ice Bank Pump comes on automatically for 1 minute, every 10 minutes.
- Level Sensor at front of Ice Bank automatically fills and maintains water level inside Ice Bank.
- Thermistor measures temperature inside Ice Bank within 0.5 degree F.
- Separate valve used to fill Ice Bank (Part #: 6519)



# InstaChill™ Cooling System

**Model 901**
**Cold and Ambient**

**Model 902**
**Cold and Hot**



Inlet to Ice Bank from Fill Valve

Alternate Location for Cold Thermistor

Inlet to Ice Bank from Filter

Stainless Steel Water Coil

Tee to Hot or Ambient Water Valve

Cold Thermistor

Evaporator

Ice Bank Pump

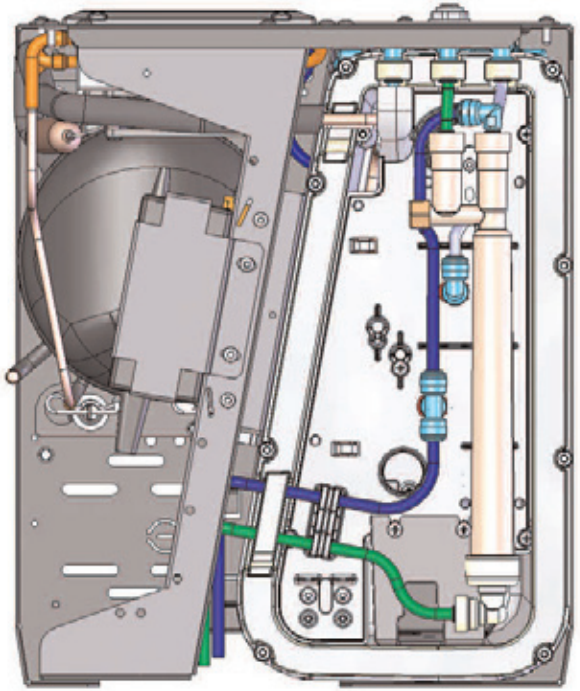
Level Sensor



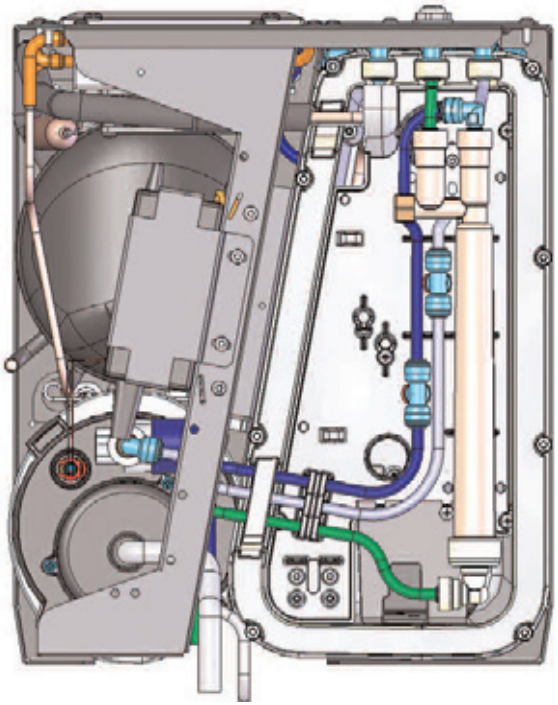
NCC7222-07 R2- 111207

# InstaChill™ Cooling System

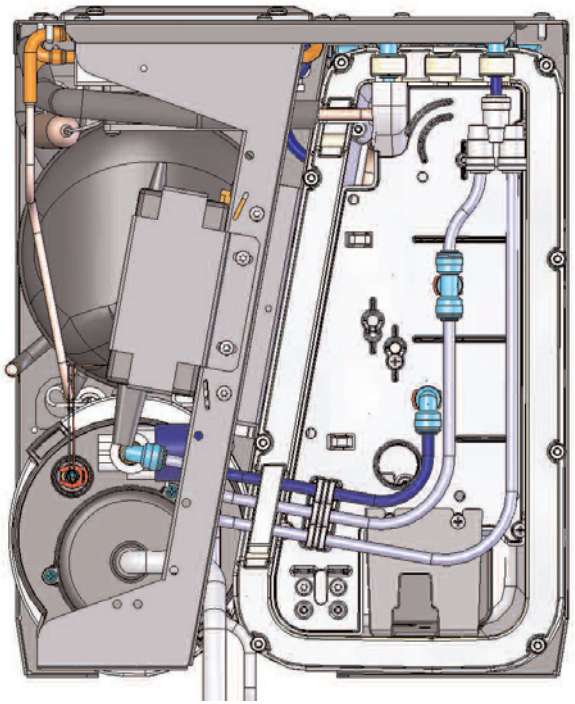
**Model 903**
**Cold and Sparkling**



**Model 904**
**Cold, Hot and Sparkling**



**Model 905**
**Cold, Hot and Ambient**



# Water Pathway

The Water pathway inside the ION is sealed and pressurized in 1/4" OD tubing (about 23' total inside the appliance).

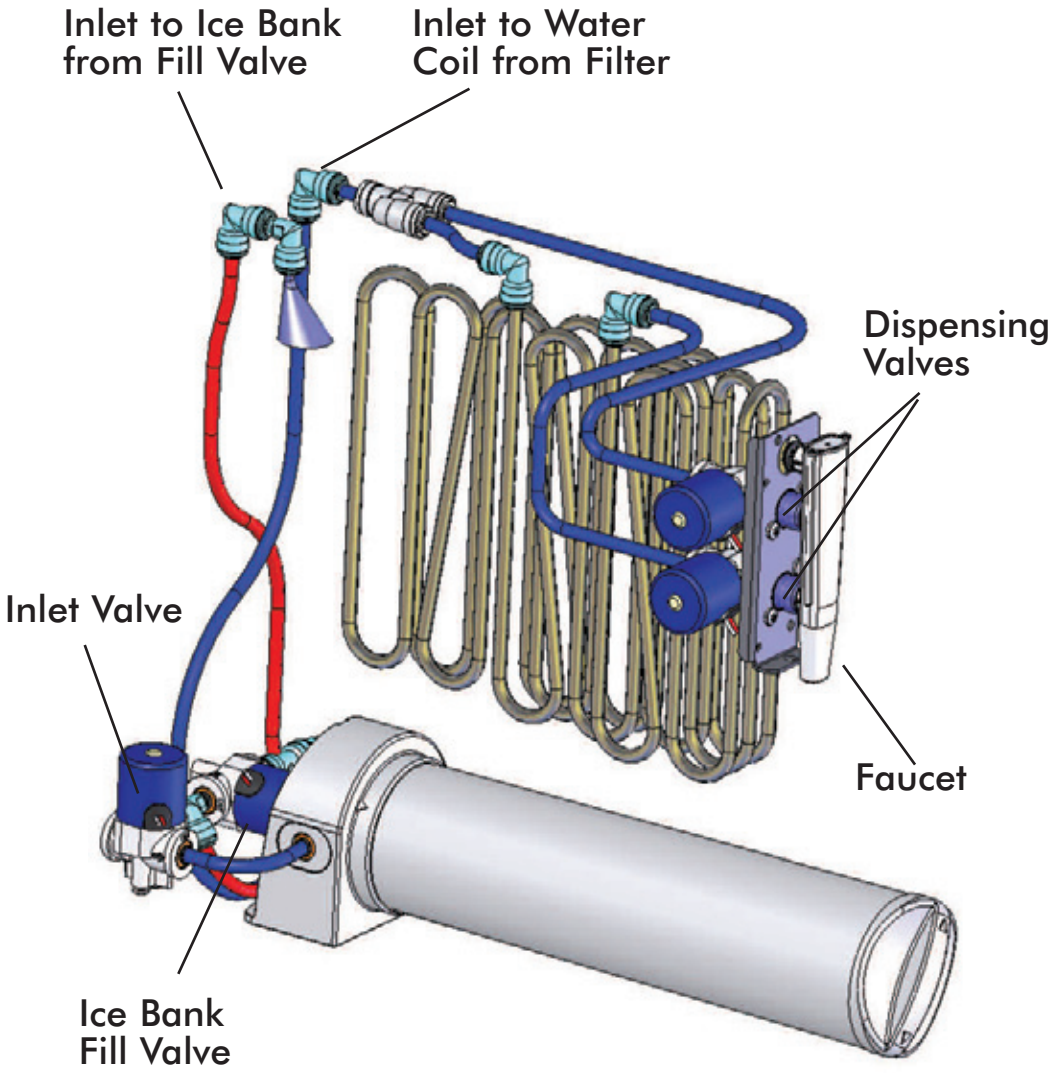
Tap Water supply tubing connects directly at the rear of the appliance to an Inlet Valve.

After the Inlet Valve, the water is directed to the Filter.

After the Filter, the Water travels up to the Ice Bank Assembly, where it is either chilled inside a Stainless Steel water coil, or bypasses to Ambient, Sparkling, or Hot Water tubing.

After the Ice Bank, water is directed to Dispensing Valves at the outlet of the appliance for Cold, Ambient, Sparkling, and Hot Water.

KEY LEARNING - when you press one of the icons on the Touch Panel, you are opening both the Inlet Valve and one of the Dispensing Valves. You will always hear TWO valves opening and TWO valves closing, in quick succession. This double click is important when troubleshooting the appliance and finding a valve which may not be opening or getting electrical current to open.



# RapidHot™ Water System

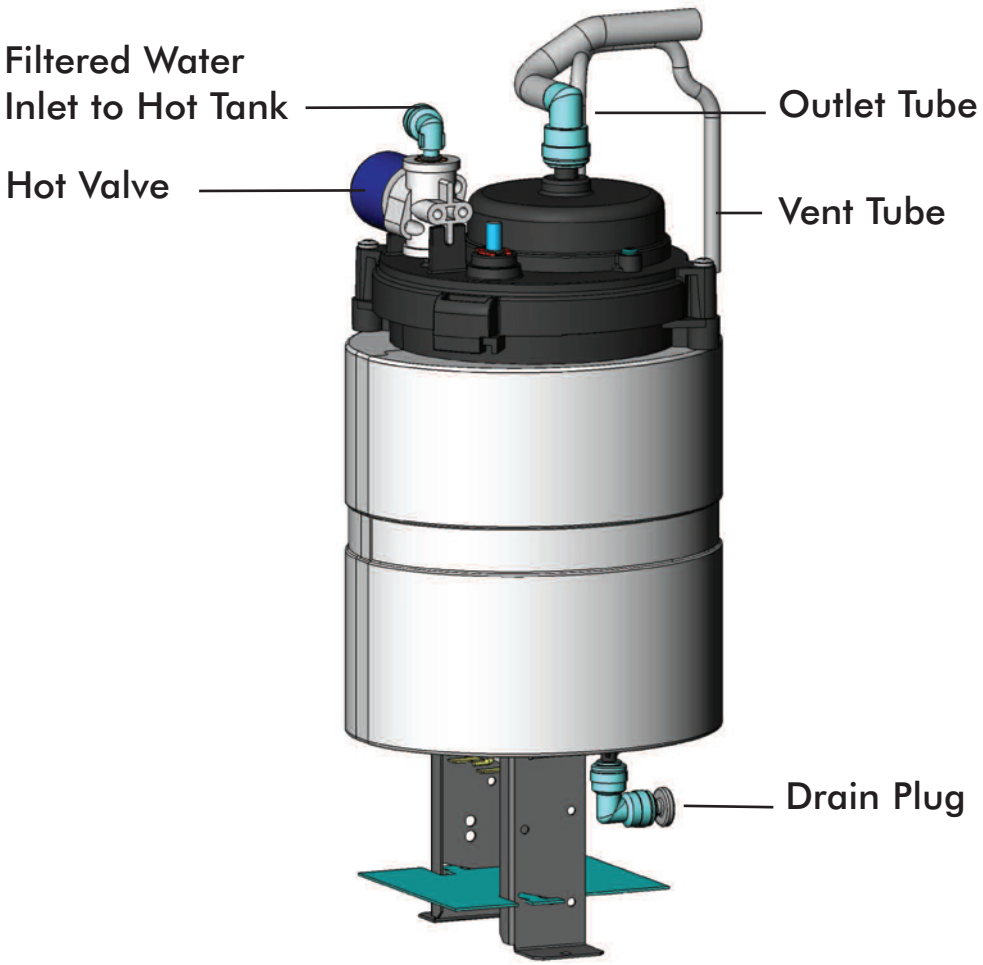
FUNCTION – Water from Filter enters Ice Bank Assembly, but is diverted with Tee fitting and bypasses the Ice Bank Water Coil.

Blue Water Tubing from Ice Bank Assembly travels to Hot Water Valve, attached to Hot Tank.

Hot Water tank is not pressurized, but extremely dangerous to service when filled with Hot Water. To cool, turn switch at rear of appliance to OFF. Then dispense water from using Hot Water icon on Touch Panel until water is cool. Then, water can be drained from Hot Tank by removing 1/4" plug at bottom of Hot Tank elbow fitting.

MANUAL FILL – On first STARTUP only, the software will force you to make sure the Hot Tank is filled. On every subsequent STARTUP, make sure the ON/OFF Switch at rear of appliance is in OFF position before connecting electrical power.

TRANSPORTATION – It is not necessary to empty the Hot Tank before transport, except in temperatures below freezing. The only outlet for water is through the Faucet. The Hot Tank contains about 4 lbs of water and can be emptied to make the appliance lighter to carry.



# ION Software

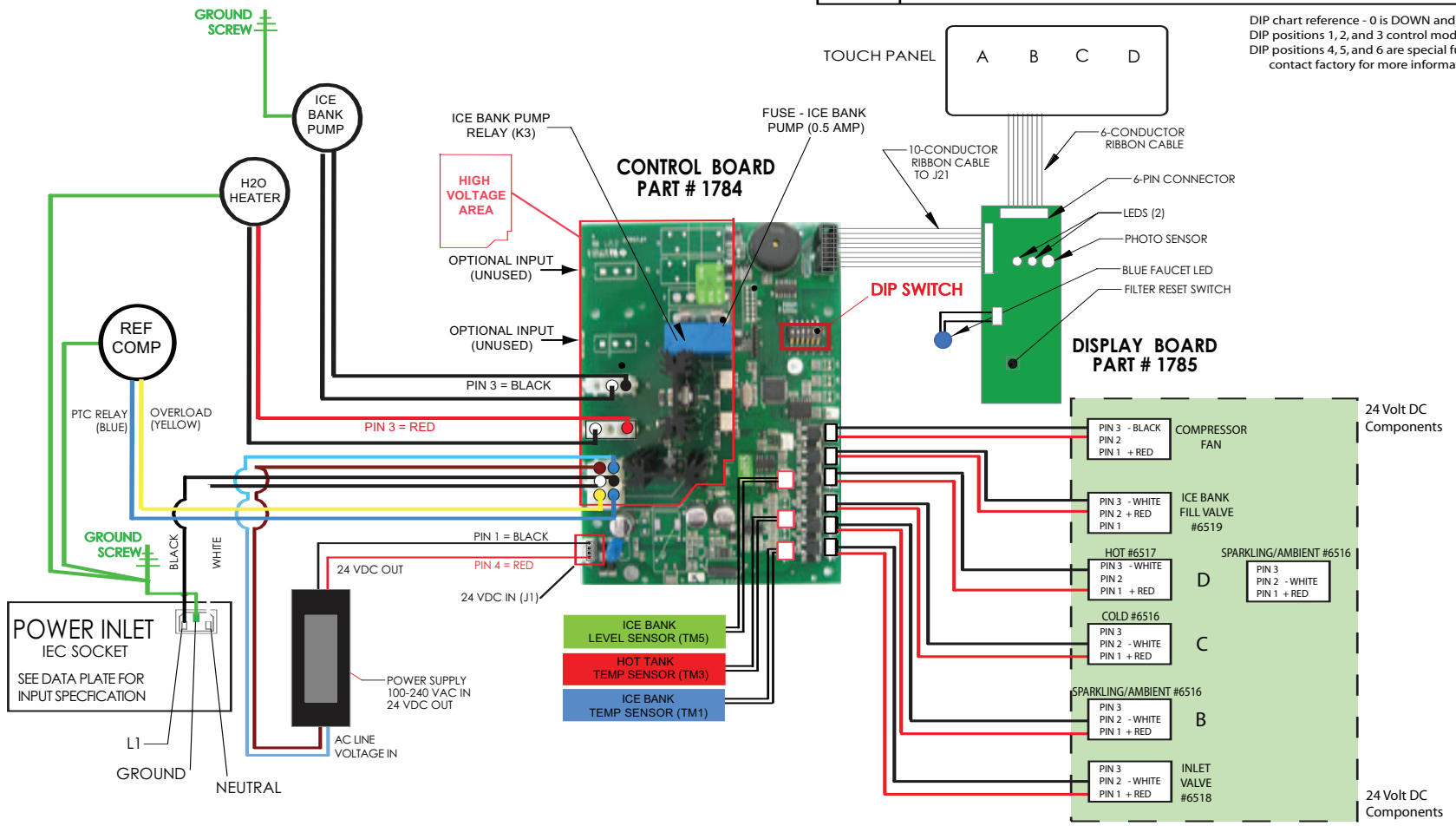
| Revision Level | Date | Notes/Changes |
|---|---|---|
| A | July 30, 2006 | Production Release.<br>SleepMode default is OFF<br>Filter Settings at 1,500 gallons and 12 months |
| B | August 13, 2006 | Changed Compressor cycle times |
| C | October 27, 2006 | Increased Hot Temperature settings |
| D | December 10, 2006 | Minor coding change |
| E | April 15, 2007 | Changed Ice Bank Pump ON time from 30 seconds to 60 seconds<br>SleepMode default is ON |
| F | May 31, 2007 | Changed Level Sensor setting. |
| G | | not implemented |
| H | June 6, 2007 | Corrected Filter Reset button to change LED's green<br>Filter Monitor Settings – default OFF |
| J | June 25, 2007 | Compressor Max ON and REST times added<br>Added Model 900 (all dip switches DOWN)<br>Added Dispense Error code for 2 minute dispense and 12 times/minute<br>Added Compressor/Fan fail check … if temp not lower after 1 hour, then LED signal error |
| K | July 29, 2007 | Changed Code to new processor |
| L | August 24, 2007 | Corrected Compressor timing loops. |

# Wiring Diagram

**DANGER-RISK OF DEATH**
**WARNING-HIGH VOLTAGE ON MAIN CONTROL BOARD. ALWAYS UNPLUG POWER SUPPLY TO UNIT BEFORE SERVICE.**

| Model | Valves | Touch Panel Location | Circuit Board Location | DIP Setting |
|---|---|---|---|---|
| 901 | Cold #6516<br>Ambient #6516 | C<br>D | C<br>D | 1 0 0 0 0 0 |
| 902 | Cold #6516<br>Hot #6517 | C<br>D | C<br>D | 0 1 0 0 0 0 |
| 903 | Cold #6516<br>Sparkling #6516 | C<br>D | C<br>D | 1 1 0 0 0 0 |
| 904 | Cold #6516<br>Hot #6517<br>Sparkling #6516 | C<br>D<br>B | C<br>D<br>B | 0 0 1 0 0 0 |
| 905 | Cold #6516<br>Hot #6517<br>Ambient #6516 | C<br>D<br>B | C<br>D<br>B | 1 0 1 0 0 0 |

DIP chart reference - 0 is DOWN and 1 is UP
DIP positions 1, 2, and 3 control model setting
DIP positions 4, 5, and 6 are special function
contact factory for more information



# Troubleshooting Guide

**Problem:**


| | |
|---|---|
| Water Dispenses from Cold or Sparkling Valve, but Water not Cold | page 11 |
| No Water Dispenses From Cold or Sparkling Valve | page 12 |
| Water dispenses from Hot Valve, but water not Hot | page 13 |
| No Water dispenses from Hot Valve | page 14 |
| Low or No Water Flow | page 15 |
| Blue LED not ON | page 16 |
| Blinking RED lights (both together, not alternating) | page 17 |
| Steady Orange lights (never goes to blinking Orange lights) | page 18 |
| Water Leak | page 19 |
| Steady RED lights – Filter Change required. When pressing Filter Reset button, does not reset RED lights to GREEN. | page 20 |




NCC7222-07 R2- 111207

# Troubleshooting Chart

## Problem: Water Dispenses from Cold or Sparkling Valve, but Water not Cold

| Cause | Action |
|---|---|
| 1. ION has been in SleepMode (with compressor off) for weekend or long holiday. | 1. Allow ice to build over 3-4 hour time period. Optionally, program SleepMode to be OFF (Ice Bank to be maintained 24 hours per day). |
| 2. ION is constantly in SleepMode<br>- is cooler in room with low level lighting?<br>- is Blue LED ON or OFF? | 2. If Blue LED is OFF, this indicates ION is in SleepMode. To lockout ION from SleepMode, see programming section in Owners Manual. |
| 3. ION may be plugged into outlet controlled by light switch. | 3. Change Outlet and retest. |
| 4. Is Fan operating? | 4. Check wiring at Control Board. |
| 5. Is Compressor Running? | 5. Check wiring at Control Board |
| 6. Freon Leak. | 6. If no ice after 3 hours of Compressor and Fan operating, call factory. |
| 7. Software bug | 7. Software Rev Level J and K have higher than normal incidence of compressor malfunction – either freeze-up or no ice condition. Call factory for replacement of product or new Circuit Board. |



NCC7222-07 R2- 111207

# Troubleshooting Guide

## Problem: No Water Dispenses From Cold or Sparkling Valve

IMPORTANT – Do you hear both Inlet Valve and Cold Valve "double-click" when opening and closing? Inlet Valve must open to allow water into ION. Dispensing Valve then allows water out of appliance. Therefore, when dispensing water, you will hear two valves clicking open and closed in quick succession. The clicking indicates the plunger is moving up and down and that the valve has electrical current. Place your finger on the back of the appliance where Inlet Valve is located and you can feel it click open and closed. Place your finger on Dispensing valve and you can also hear it click open and closed. A dead valve (no electrical current) is indicated when you cannot feel the plunger moving up inside.

| Cause | Action |
|---|---|
| 1. Dead Valve - No electrical current. | 1. Check Touch Panel connector to Display Board, behind Front Panel.<br>Check valve wiring on Control Board.<br>Check DIP Switch setting for correct ION model (see wiring diagram). |
| 2. Valves are clicking, indicating electrical current is present. | 2. Double-check Water Supply tubing, shutoff valves, and undersink connection.<br><br>Check inside Ice Bank for frozen Ice Bank … thaw and set DIP 4 to UP position. Or contact factory for latest software revision level. |



NCC7222-07 R2- 111207

# Troubleshooting Guide

Problem: Water dispenses from Hot Valve, but water not Hot

| Cause | Action |
|---|---|
| 1. ON/OFF switch at back of ION | 1. Turn to ON position. |
| 2. Wiring and connectors at Control Board | 2. Check for continuity (not voltage) through the hot tank connector and wiring harness at Control Board (with ION unplugged and Switch in ON position). |
| 3. Thermal Overload in Hot Tank Assembly has been tripped (from dry-firing hot tank). | 3. Replace Thermal Overload (this is very rare as the software does not allow temperature to rise quickly inside hot tank). Instead you will get an LED error message reminding you to fill the hot tank and check the thermistor. |
| 4. Faulty Control Board. | 4. Replace Control Board. |

# Troubleshooting Guide

Problem: No Water dispenses from Hot Valve

| Cause | Action |
|---|---|
| 1. Are customers pressing BOTH Hot and Safety button at same time? | 1. Refer to Instruction Label inside filter door of appliance and notify customer.<br>2. Do you hear both Inlet and Dispensing Valve clicking open and closed?. |
| 2. Do you hear both Inlet and Dispensing Valve clicking open and closed? | 2. Check for dead valve or water supply problem.<br>Check DIP switches on Control Board (see wiring diagram).<br>Check Valve Wiring on Control Board (see wiring diagram). |

# Troubleshooting Guide

## Problem: Low or No Water Flow

IMPORTANT – Keep in mind that inside the ION, there is a 1 micron carbon filter and 23′ of 1/4″ tubing (the Water Coil is 20′ in length). Plan ahead for adequate water pressure and flow rate into the ION.

| Cause | Action |
|---|---|
| 1. Using 1/4″ water supply tubing may restrict water flow, depending on available water pressure inside building. | 1. Change to 3/8″ water supply tubing. |
| 2. Inlet Valve is quick connect fitting that requires cleanly cut 1/4″ water supply tubing. | 2. Check water supply tubing and cut cleanly with razor knife. |
| 3. Is copper tubing used at Inlet Valve? | 3. Do not use copper tubing to connect to ION appliance … use a 1/4″ compression union fitting and only connect to ION with plastic tubing. |

# Troubleshooting Guide

## Problem: Blue LED not ON

IMPORTANT – SleepMode is an energy saving feature that is programmed into the Control Board. A photo sensor behind the LED3 on Front Panel allows software to turn the compressor OFF when room is dark.

Check the location carefully… if room light is turned ON and OFF frequently during the day, this will be a problem for the cooling system. See Owners Manual, programming section, and program the SleepMode feature to be OFF.

When SleepMode is ON, compressor is OFF after room is dark for 5 minutes; hot tank drops to 135F. When any button is pressed, OR in light room after 5 minutes, SleepMode cycle ends, and hot tank and compressor are both ON as needed to reach temperature.

| Cause | Action |
|---|---|
| 1. Loose connection behind Front Panel at Display Board | 1. Reconnect or replace as needed. |
| 2. ION in SleepMode | 2. In very low light, after 5 minutes, ION goes into SleepMode (default setting) unless programmed OFF (see Owners Manual, programming section). |

# Troubleshooting Guide

**Problem: Blinking RED lights (both together, not alternating)**

IMPORTANT – Ice Bank automatically fills by using a Level Sensor. To prevent endless water flow from failed Level Sensor, software only allows the Ice Bank to fill for 5 minutes on STARTUP. Once the ION has passed STARTUP, the Ice Bank is limited to a fill time of 2 minutes. To fill the Ice Bank, you will need to unplug and reconnect the ION to electrical outlet until the Ice Bank is filled.

| Cause | Action |
|---|---|
| 1. Level Sensor Timeout | 1. Unplug ION and reconnect to electrical supply.<br><br>Continue as need until Ice Bank is filled and LED1 and LED2 are both Green and Steady (with Blue LED under the faucet). This indicates Normal Operation. |

# Troubleshooting Guide

## Problem: Steady Orange lights (never goes to blinking Orange lights)

IMPORTANT – on software rev level prior to L (Sept. 2007), a hot or cold sensor unplugged (or not completely connected) will cause this condition. During shipping, the sensor connections can become unstable and may require careful removal (straight back) and reinsertion onto the Control Board (see wiring diagram). CAUTION – unplug ION before any contact with Control Board.

| Cause | Action |
|---|---|
| 1. Are Cold and Hot sensors (thermistors) in the correct position? | 1. Check wiring diagram, remove, and reinsert. CAUTION - unplug ION before any contact with Control Board. |
| 2. On Models produced after September 1 … can you hear a single initialization beep when ION is first plugged in? | 2. If YES, then double check sensor wires and replace sensors as needed.<br><br>If NO, then replace Control Board – programming error or defect on Control Board (perhaps, shipping damage) is preventing Control Board from initialization. |

# Troubleshooting Guide

## Problem: Water Leak

IMPORTANT – the ION uses an Inlet Valve to allow water to enter the appliance. Only when the customer presses Touch Panel to dispense water – or when Ice Bank automatically fills – does the Inlet Valve open to allow water to enter the appliance.

On units with "Bypass" feature, the Inlet Valve is bypassed to allow for Filter Water from the ION to be routed out the back of the appliance and over to a coffee machine. This option provide for continuous water flow (bypassing the Inlet Valve) and is not recommended for installations that want to maintain the maximum level of leak prevention.

| Cause | Action |
|---|---|
| 1. Filter not completely rotated into correct position. | 1. Some filters (produced June 2007) have been spinwelded incorrectly and can only be rotated clockwise into ION to a certain point. If you want these filters replaced, contact the factory. |
| 2. Ice Bank leak | 2. Level inside Ice Bank is checked by software every 24 hours and refilled (2 minute limit)… a small pinhole leak inside Ice Bank can cause leak. Contact factory for replacement. |
| 3. Tubing, Fitting, or Valve Leak | 3. Check all fittings, tubing, and valves, and repair as needed. |



NCC7222-07 R2- 111207

# Troubleshooting Guide

**Problem: Steady RED lights – Filter Change required.**
**When pressing Filter Reset button, does not reset RED lights to GREEN.**

IMPORTANT – When changing filters, ALWAYS reset the filter monitor (time and gallons) to zero by pressing the Filter Reset button until you hear a beep (about 6 seconds).

The Filter monitor works as follows: (1) Gallons (can be set for 750, 100, or 1,500 gallons) based on 0.5 GPM flow rate; (2) Time (elapsed calendar time of 3 months, 6 months, or 12 months).

On models produced after June 2007, an optional setting of OFF for either Gallons or Time is available… see Owners Manual for programming instructions.

| Cause | Action |
|---|---|
| 1. On units produced prior to June 2007, a software bug may not allow the LED's to be reset to GREEN. | 1. Unplug the ION, and for first few seconds, the LED's will start out as GREEN, quickly press the Filter Reset button and gold until you hear an audible beep.<br><br>LED's will remain GREEN.<br><br>Contact factory if any further difficulty. |



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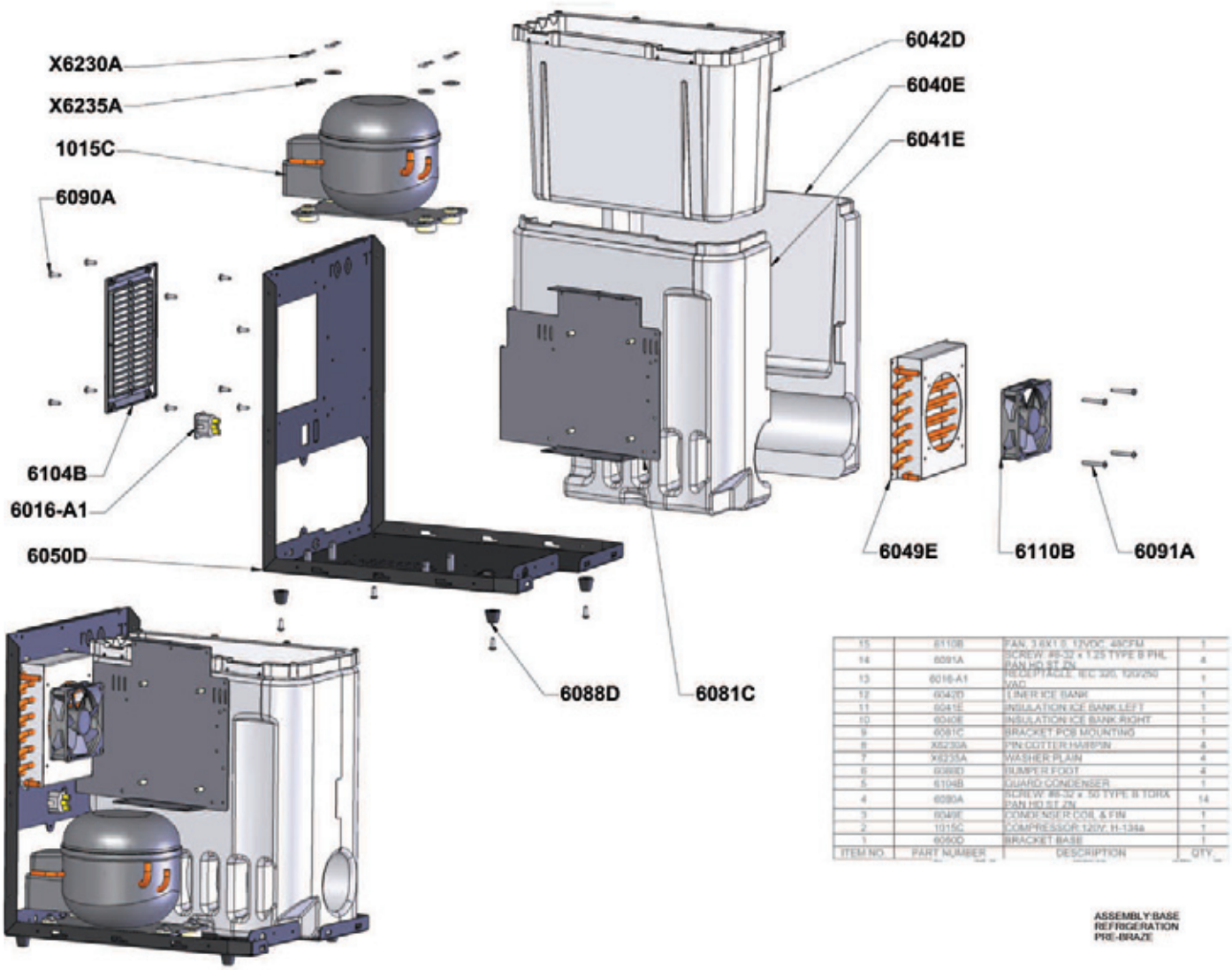
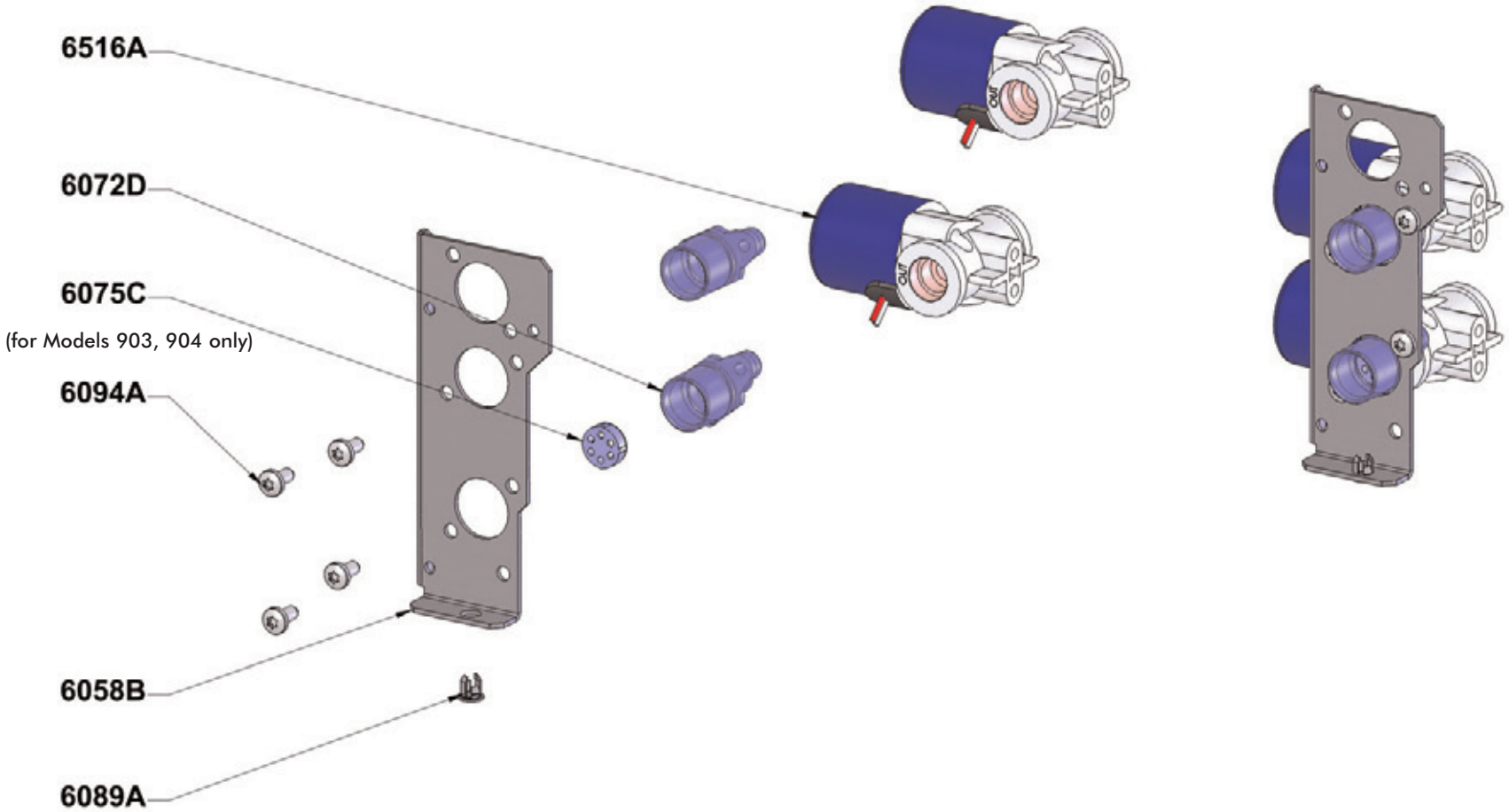
# Frame Assembly



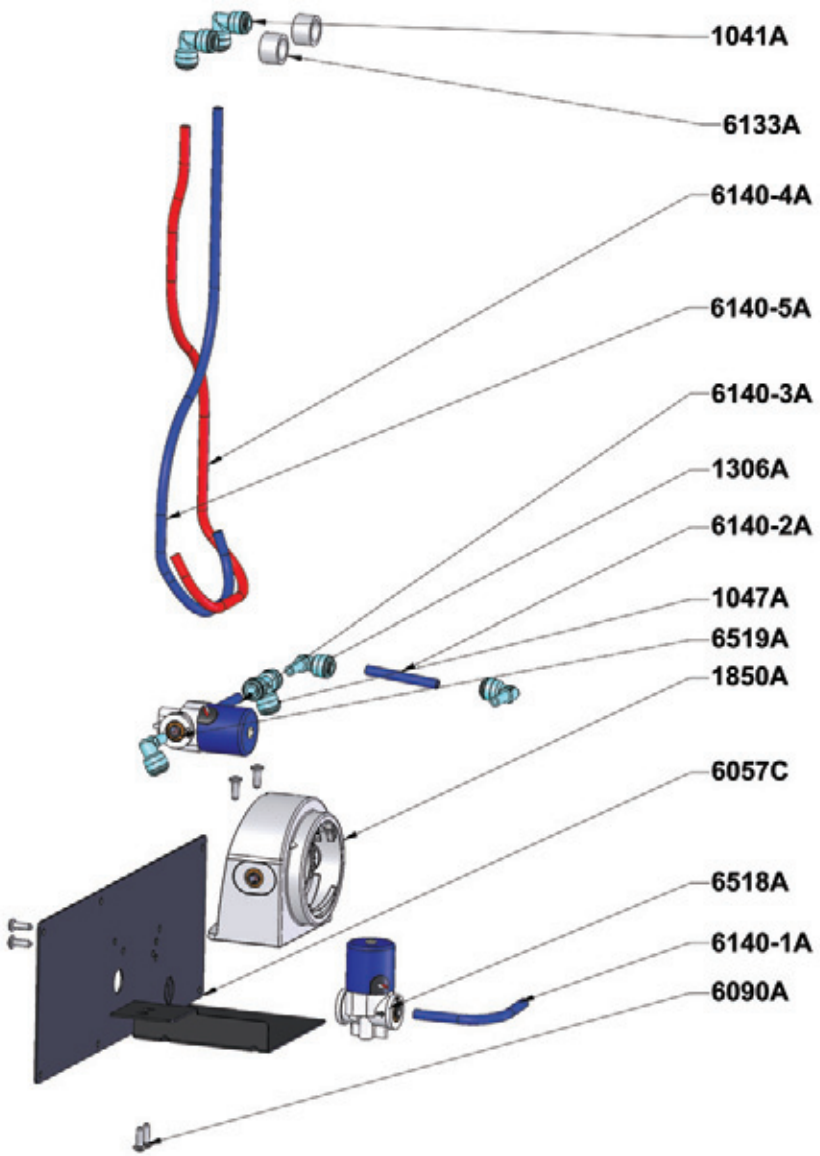

| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 15 | 6110B | FAN, 3.6X1.5, 12VDC, 48CFM | 1 |
| 14 | 6091A | SCREW, #6-32 x 1.25 TYPE B PHL PAN HD ST ZN | 4 |
| 13 | 6016-A1 | RECEPTACLE, IEC 320, 120/250 VAC | 1 |
| 12 | 6042D | LINER ICE BANK | 1 |
| 11 | 6041E | INSULATION ICE BANK LEFT | 1 |
| 10 | 6040E | INSULATION ICE BANK RIGHT | 1 |
| 9 | 6081C | BRACKET PCB MOUNTING | 1 |
| 8 | X6230A | PIN COTTER HAIRPIN | 4 |
| 7 | X6235A | WASHER PLAIN | 4 |
| 6 | 6088D | BUMPER FOOT | 4 |
| 5 | 6104B | GUARD CONDENSER | 1 |
| 4 | 6090A | SCREW, #6-32 x .50 TYPE B TORX PAN HD ST ZN | 14 |
| 3 | 6049E | CONDENSER COIL & FIN | 1 |
| 2 | 1015C | COMPRESSOR 120V, R-134a | 1 |
| 1 | 6050D | BRACKET BASE | 1 |

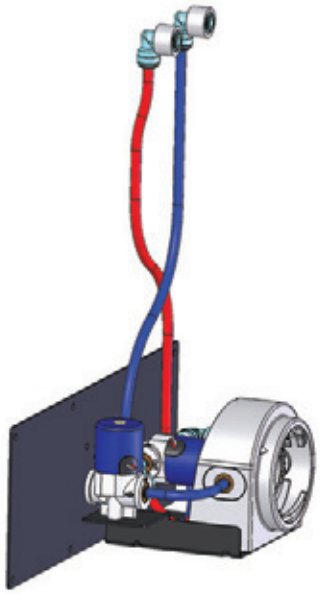
ASSEMBLY BASE
REFRIGERATION
PRE-BRAZE

# Display Valve Assembly (Models 903,904 only)



# Filter Manifold Assembly

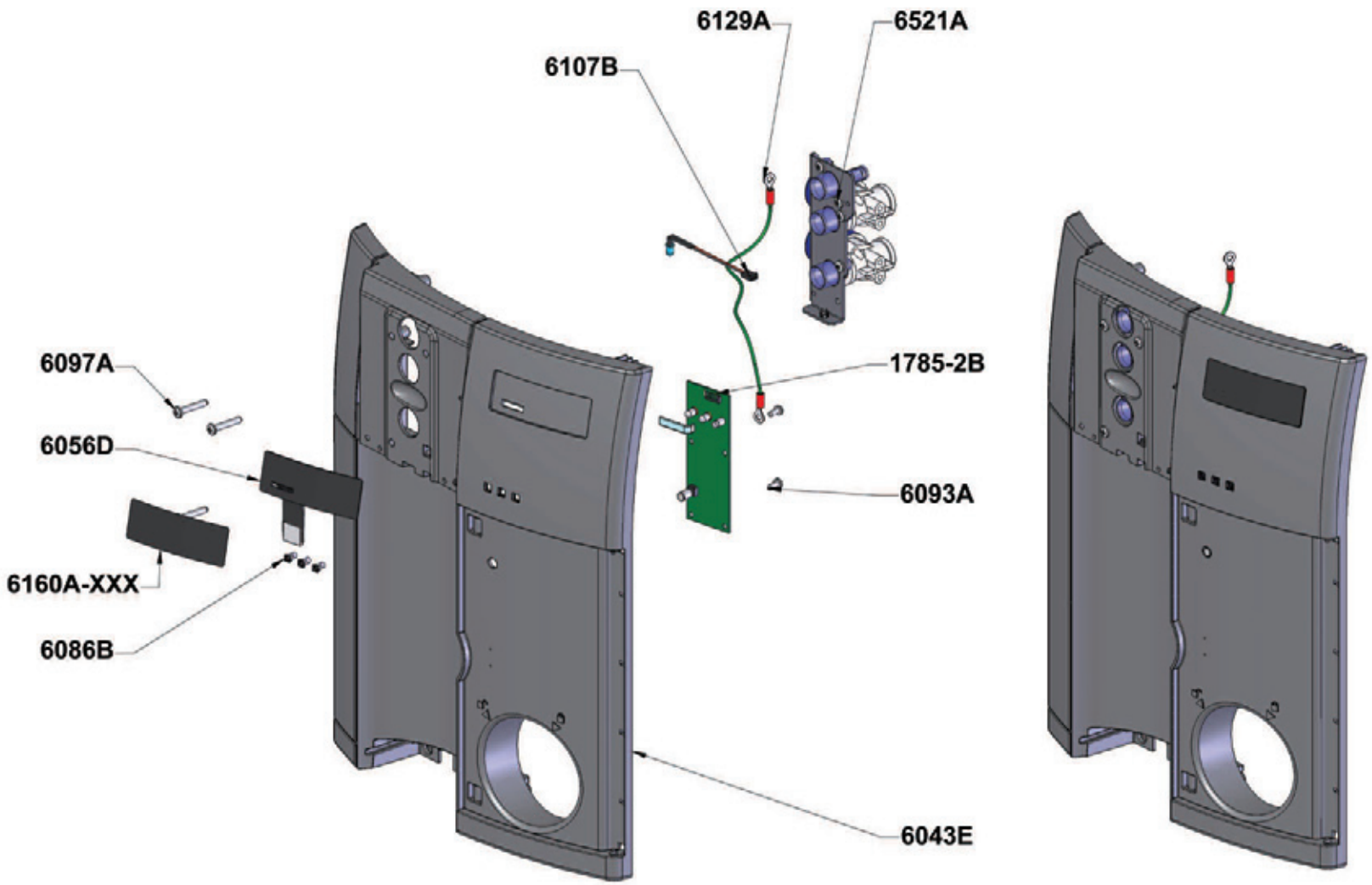


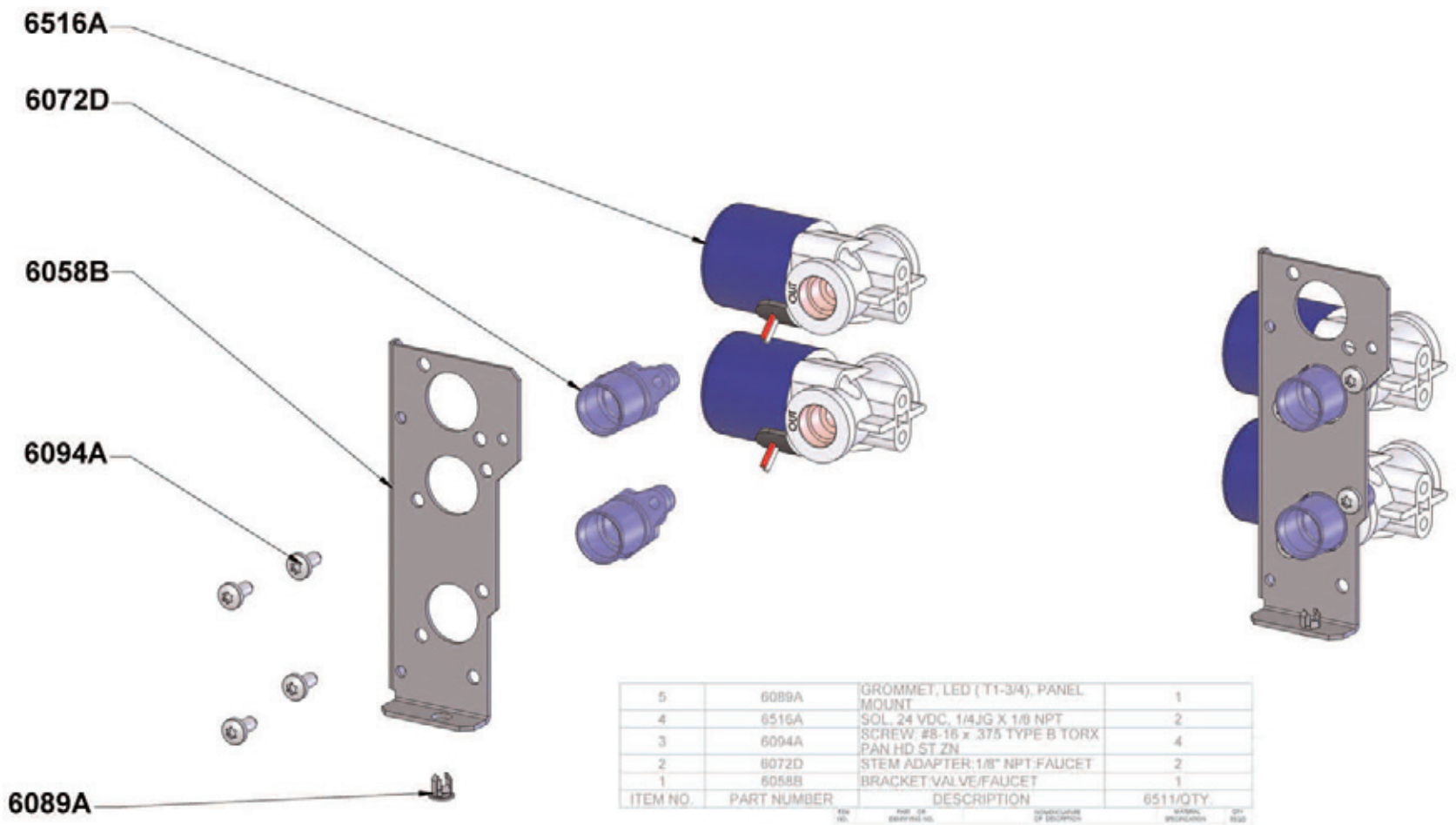
| | | | |
|---|---|---|---|
| 14 | | SEAL FITTING IB | 2 |
| 13 | | FITTING:1/4" QC UNION ELBOW | 2 |
| 12 | | TUBE:1/4" OD:AMBIENT H2O TO | 1 |
| 11 | | TUBE:1/4" OD:FITTING TO FITTING | 1 |
| 10 | | TUBE:1/4" OD:INLET VALVE TO FILTER MANIFOLD | 1 |
| 9 | | TUBE:1/4" OD:FILL VALVE TO ICE TANK | 1 |
| 8 | | TUBE:1/4" OD:FILTER MANIFOLD TO FITTING | 1 |
| 7 | | SOL, 24 VDC, 1/4JG X | 1 |
| 6 | | SOL, 24 VDC, 1/4JG X | 1 |
| 5 | | SCREW: #8-32 x .50 TYPE B TORX PAN HD ST ZN | 6 |
| 4 | | FITTING:1/4" QC UNION TEE | 1 |
| 3 | | FITTING:1/4" QC STEM ELBOW | 3 |
| 2 | | MANIFOLD FILTER w/o COVER | 1 |
| 1 | | BRACKET:INLET VALVE/FILTER | 1 |
| | PART NUMBER | DESCRIPTION | 901, 902 & |

ASSEMBLY:INLET VALVE/
FILTER MANIFOLD BRKT
MODELS 901, 902 & 905

# Front Panel Assembly



# Dispensing Assembly – 901




| ITEM NO. | PART NUMBER | DESCRIPTION | 6511/QTY. |
|---|---|---|---|
| 5 | 6089A | GROMMET, LED ( T1-3/4), PANEL MOUNT | 1 |
| 4 | 6516A | SOL, 24 VDC, 1/4JG X 1/8 NPT | 2 |
| 3 | 6094A | SCREW: #8-16 x .375 TYPE B TORX PAN HD ST ZN | 4 |
| 2 | 6072D | STEM ADAPTER:1/8" NPT:FAUCET | 2 |
| 1 | 6058B | BRACKET:VALVE/FAUCET | 1 |

PARTS LIST

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ANGLES

SEE NOTES

KR 11DEC06

NATURAL CHOICE CORP.
748 LANDMARK DR., BELVIDERE, IL 61008

ASSEMBLY:FAUCET
VALVE BRACKET - 901

NEXT ASSY USED ON

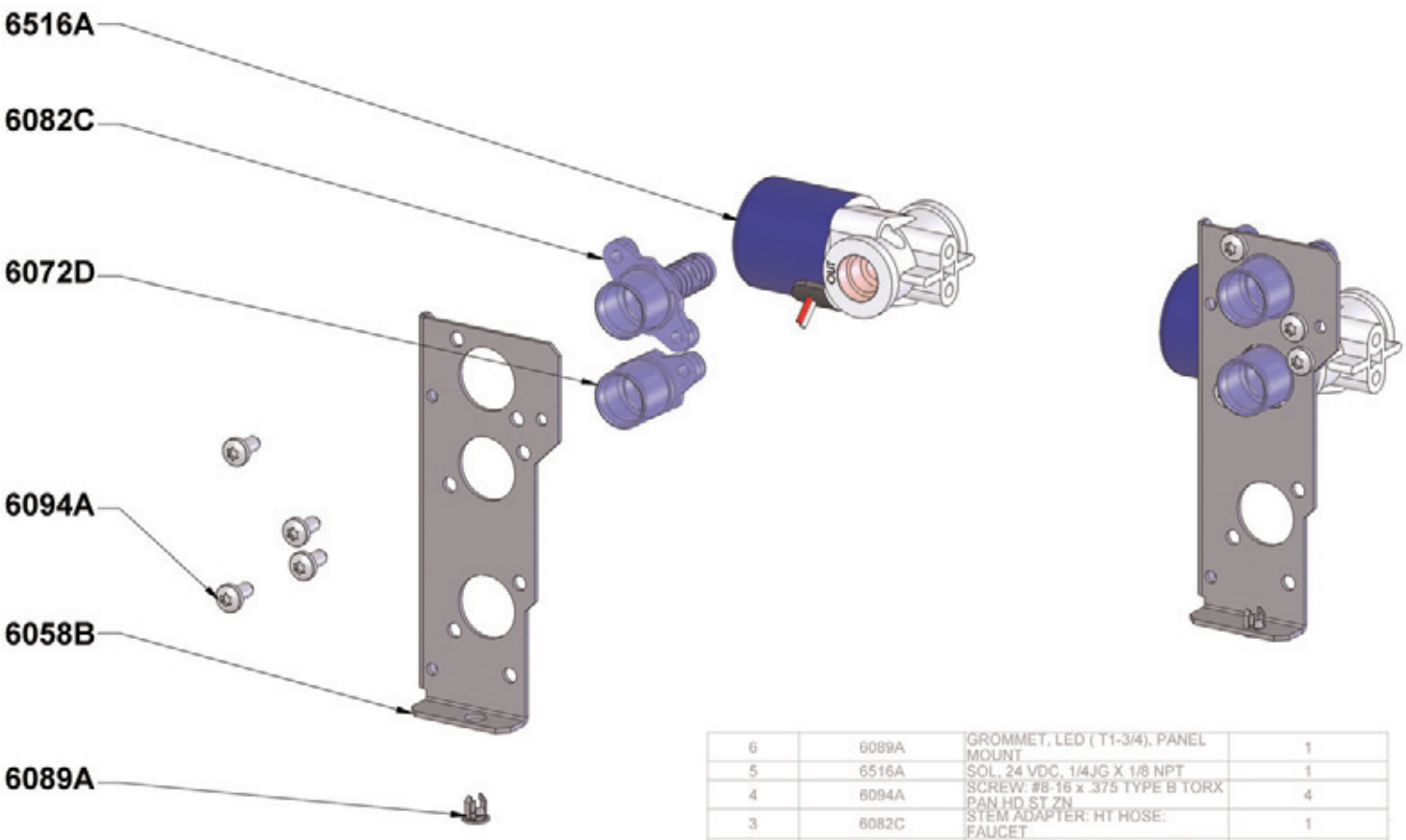
APPLICATION

DO NOT SCALE DRAWING

C 6511A A

SCALE 1 SHEET 1 OF 1

# Dispensing Assembly – 902




| ITEM NO. | PART NUMBER | DESCRIPTION | 6512/QTY. |
|---|---|---|---|
| 6 | 6089A | GROMMET, LED ( T1-3/4), PANEL MOUNT | 1 |
| 5 | 6516A | SOL, 24 VDC, 1/4JG X 1/8 NPT | 1 |
| 4 | 6094A | SCREW: #8-16 x .375 TYPE B TORX PAN HD ST ZN | 4 |
| 3 | 6082C | STEM ADAPTER: HT HOSE: FAUCET | 1 |
| 2 | 6072D | STEM ADAPTER:1/8" NPT:FAUCET | 1 |
| 1 | 6058B | BRACKET:VALVE/FAUCET | 1 |

PARTS LIST

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
SEE NOTES

CAD-GENERATED DRAWING. DO NOT MANUALLY UPDATE

APPROVALS DATE
Drawn KR 11DEC06
CHECKED
ENG APP.
MFG APP.
QUAL APP.

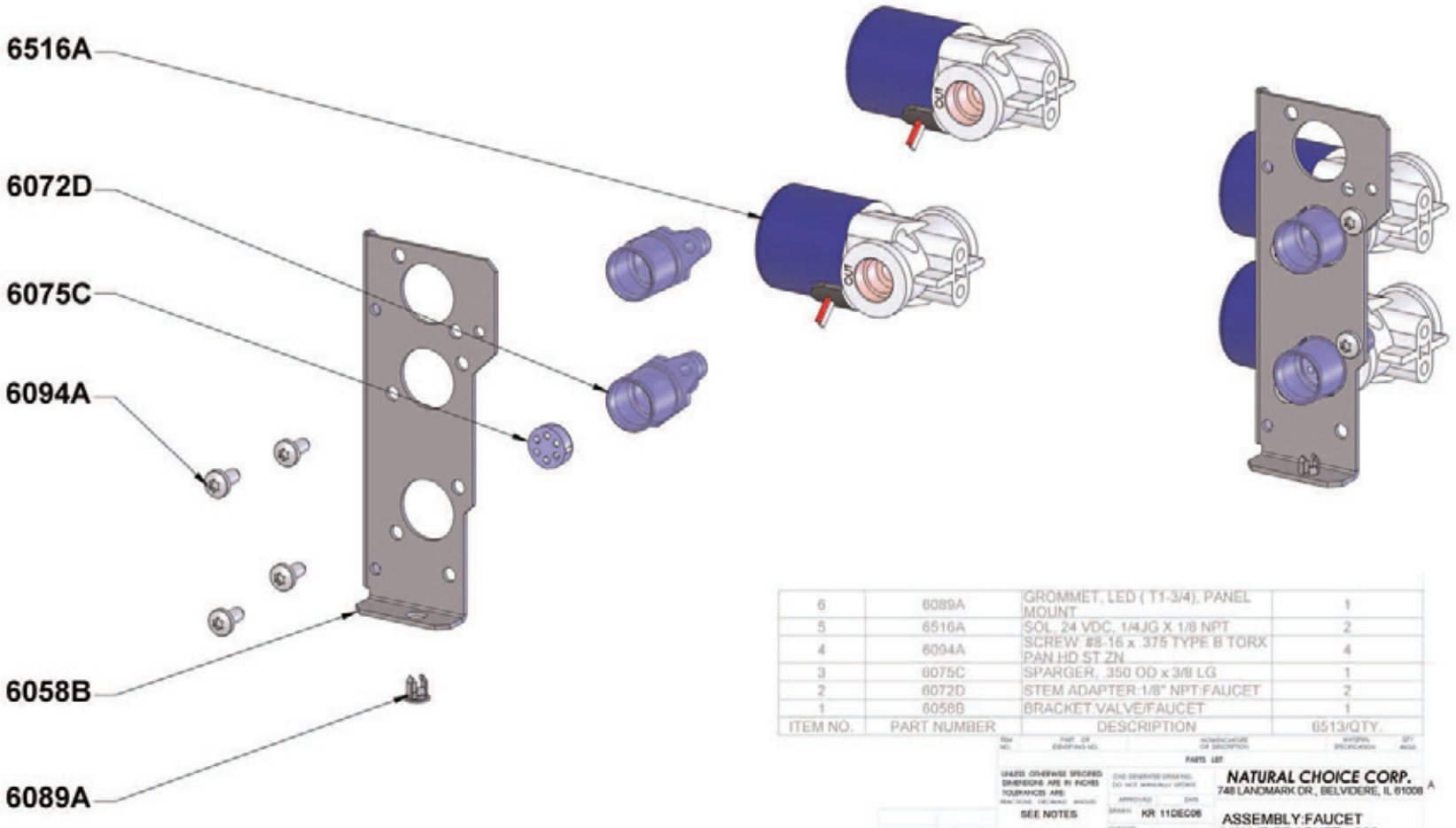
NATURAL CHOICE CORP.
748 LANDMARK DR., BELVIDERE, IL 61008

ASSEMBLY:FAUCET
VALVE BRACKET - 902

SIZE DWG. NO. 6512A REV A
C
SCALE CAD FILE SHEET

NEXT ASSY USED ON
APPLICATION
DO NOT SCALE DRAWING

# Dispensing Assembly – 903




| ITEM NO. | PART NUMBER | DESCRIPTION | 6513/QTY. |
|---|---|---|---|
| 6 | 6089A | GROMMET, LED ( T1-3/4), PANEL MOUNT | 1 |
| 5 | 6516A | SOL, 24 VDC, 1/4JG X 1/8 NPT | 2 |
| 4 | 6094A | SCREW: #8-16 x .375 TYPE B TORX PAN HD ST ZN | 4 |
| 3 | 6075C | SPARGER, .350 OD x 3/8 LG | 1 |
| 2 | 6072D | STEM ADAPTER:1/8" NPT:FAUCET | 2 |
| 1 | 6058B | BRACKET:VALVE/FAUCET | 1 |

PARTS LIST

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:

SEE NOTES

KR 11DEC06

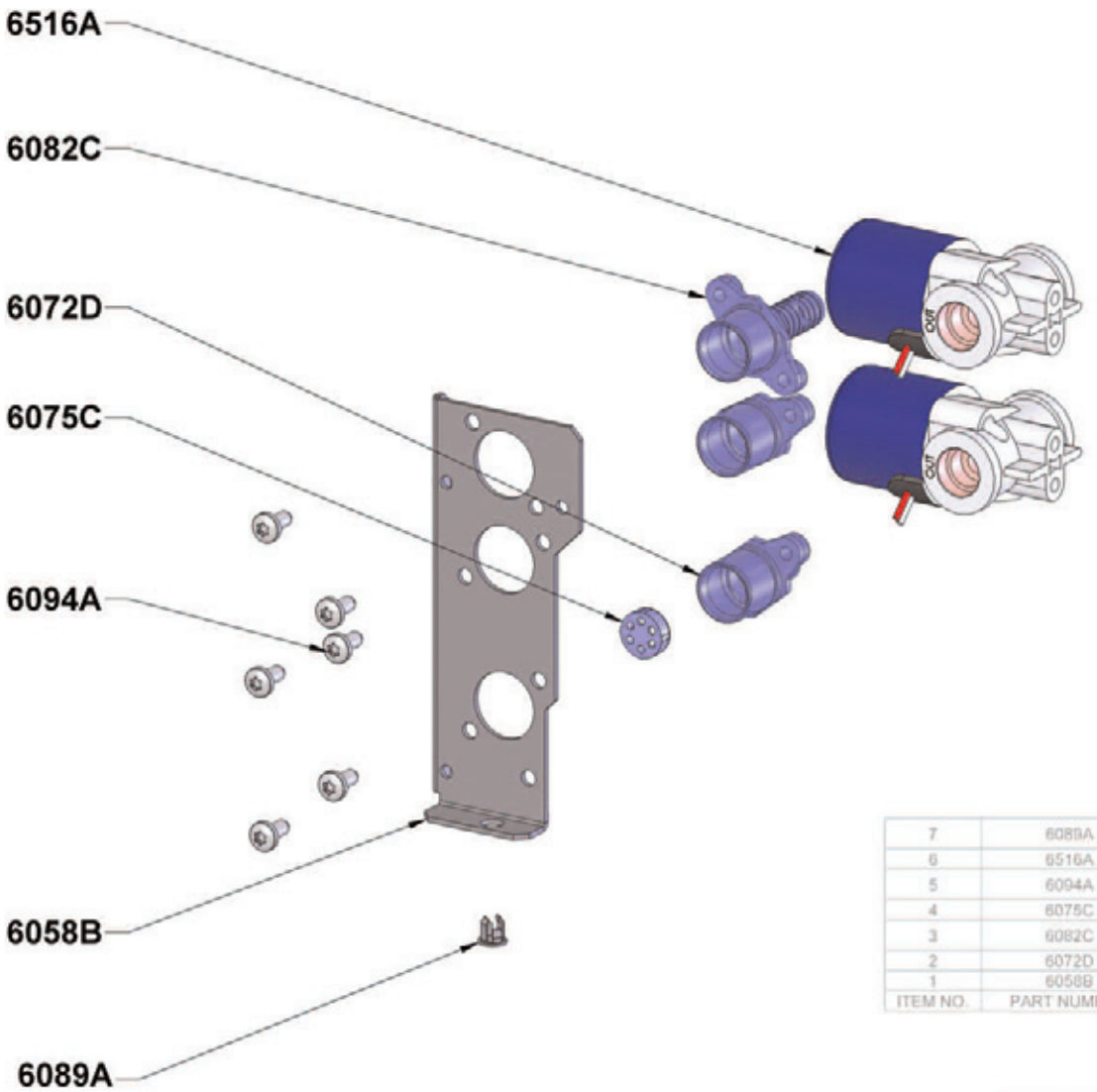
NATURAL CHOICE CORP.
748 LANDMARK DR., BELVIDERE, IL 61008

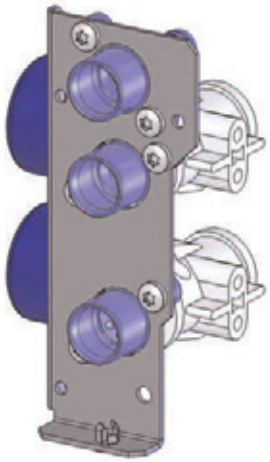
ASSEMBLY:FAUCET VALVE BRACKET - 903

C 6513A A

DO NOT SCALE DRAWING

# Dispensing Assembly – 904



| ITEM NO. | PART NUMBER | DESCRIPTION | 6514/QTY. |
|---|---|---|---|
| 7 | 6089A | GROMMET, LED ( T1-3/4), PANEL MOUNT | 1 |
| 6 | 6516A | SOL, 24 VDC, 1/4JG X 1/8 NPT | 2 |
| 5 | 6094A | SCREW: #8-16 x .375 TYPE B TORX PAN HD ST ZN | 6 |
| 4 | 6075C | SPARGER, .350 OD x 3/8 LG | 1 |
| 3 | 6082C | STEM ADAPTER: HT HOSE: FAUCET | 1 |
| 2 | 6072D | STEM ADAPTER:1/8" NPT:FAUCET | 2 |
| 1 | 6058B | BRACKET:VALVE/FAUCET | 1 |

PARTS LIST

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:
SEE NOTES

KR 11DEC06

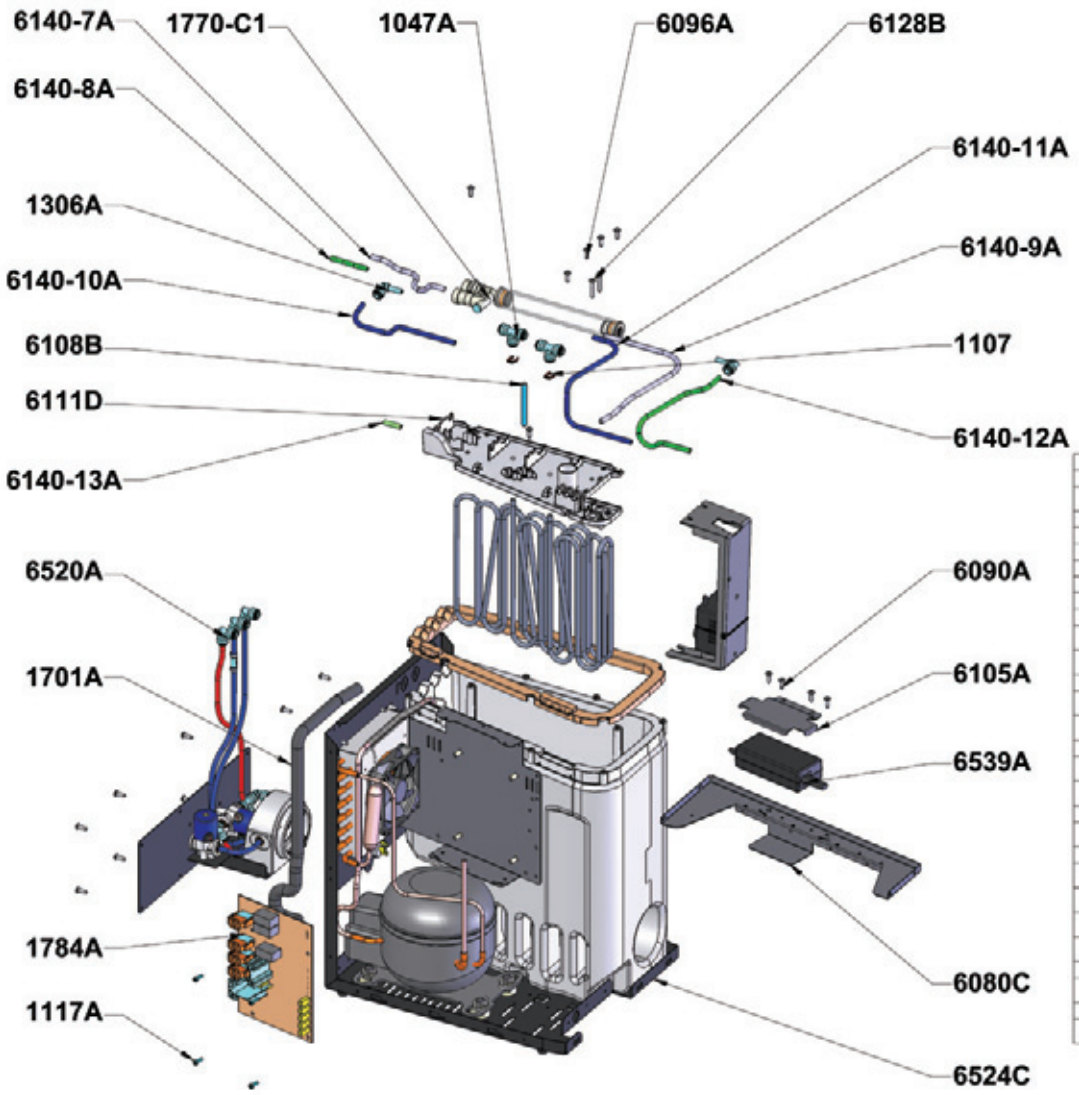
NATURAL CHOICE CORP.
748 LANDMARK DR., BELVIDERE, IL 61008

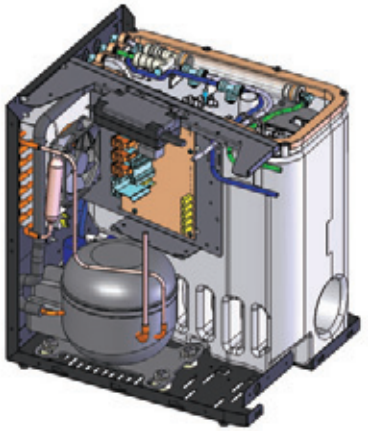
ASSEMBLY:FAUCET
VALVE BRACKET - 904

6514A

DO NOT SCALE DRAWING

# Ice Bank Assembly

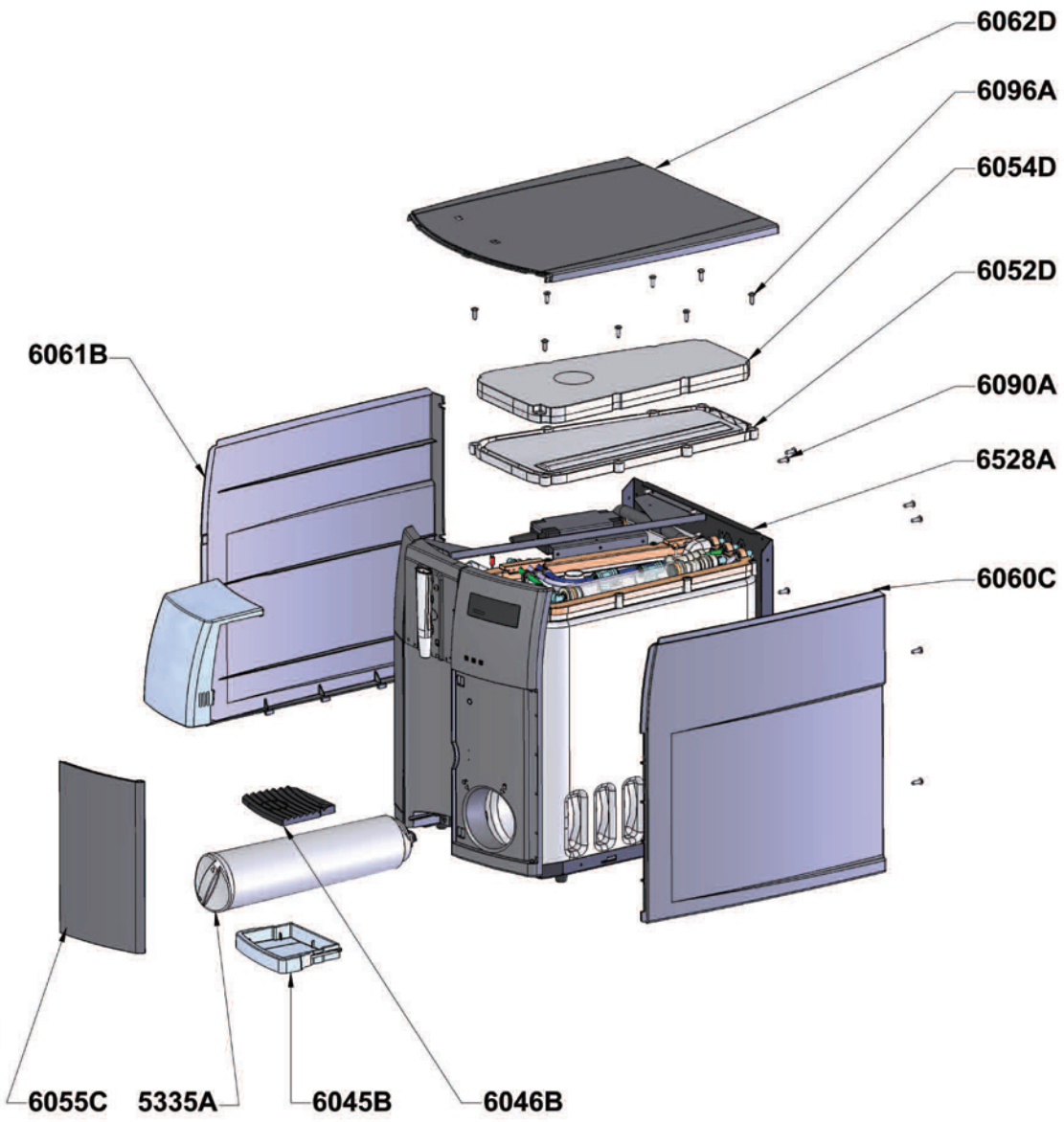


| ITEM NO. | PART NUMBER | DESCRIPTION | Default/Q TY. |
|---|---|---|---|
| 28 | 6525A | ASSEMBLY:IB PUMP BRACKET | 1 |
| 27 | X620508 | GASKET:IB COVER | 1 |
| 26 | 6105A | BRACKET:POWER SUPPLY MOUNTING | 1 |
| 25 | 6539A | ASSEMBLY:POWER SUPPLY | 1 |
| 24 | 1117A | SCREW:#6-32 x .50 PHL HD ZN | 4 |
| 23 | 1784A | PCB:MAIN: HYBRID 2 ASM | 1 |
| 22 | 6111D | PLATE BARRIER ICE BANK | 1 |
| 21 | 6073D | COIL: 1/4" SS WATER | 1 |
| 20 | 6108B | NTC SHEATHED THERMISTOR- | 1 |
| 19 | 1047A | FITTING:1/4" QC UNION TEE | 2 |
| 18 | 6140-8A | TUBE:1/4" OD:CO2 FITTING TO CARBONATOR | 1 |
| 17 | 6140-10A | TUBE:1/4" OD:TEE FITTING TO CARBONATOR | 1 |
| 16 | 6140-13A | TUBE:1/4" OD:FILL FITTING | 1 |
| 15 | 6140-7A | TUBE:1/4" OD:AMBIENT FITTING TO SS COIL | 1 |
| 14 | 6140-12A | TUBE:1/4" OD:CARBONATOR TO SPARKLING VALVE | 1 |
| 13 | 6140-9A | TUBE:1/4" OD:TEE FITTING TO HT | 1 |
| 12 | 6140-11A | TUBE:1/4" OD:TEE FITTING TO COLD VALVE | 1 |
| 11 | 6093A | SCREW: #6-19 x .375 TYPE B TORX PAN HD ST ZN | 1 |
| 10 | 1107 | CLIP:LOCKING | 2 |
| 9 | 1770-C1 | ASSY, CARBONATOR, MOLDED COMPLETE | 1 |
| 8 | 1306A | FITTING:1/4" QC STEM ELBOW | 2 |
| 7 | 6128B | SCREW: #8-16 x 1.00 TYPE B PHL PAN HD SS | 2 |
| 6 | 6080C | BRACKET:UPPER SUPPORT | 1 |
| 5 | 6096A | SCREW: #8-16 x .50 TYPE B TORX PAN HD SS | 6 |
| 4 | 6090A | SCREW: #8-32 x .50 TYPE B TORX PAN HD ST ZN | 12 |
| 3 | 6524C | ASSEMBLY:BASE REFRIGERATION | 1 |
| 2 | 6520A | ASSEMBLY:INLET VALVE/FILTER MANIFOLD BRACKET | 1 |
| 1 | 1701A | INSULATION:FOAM TAPE | 1 |

ASSEMBLY:UNIT FINAL: PRE-FRONT PANEL

# Final Assembly



| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 13 | 6096A | SCREW: #8-16 x .50 TYPE B TORX PAN HD SS | 8 |
| 12 | 6090A | SCREW: #8-32 x .50 TYPE B TORX PAN HD ST ZN | 8 |
| 11 | 6052D | COVER:ICE TANK | 1 |
| 10 | 6054D | INSULATION:COVER:ICE TANK | 1 |
| 9 | 6045B | TRAY:DRIP | 1 |
| 8 | 6046B | COVER:DRIP TRAY | 1 |
| 7 | 6044D | COVER:FAUCET | 1 |
| 6 | 6055C | DOOR:FILTER ACCESS | 1 |
| 5 | 6062D | COVER:TOP | 1 |
| 4 | 6060C | COVER:RIGHT SIDE | 1 |
| 3 | 6061B | COVER:LEFT SIDE | 1 |
| 2 | 5335A | CARTRIDGE:CARBON FILTER | 1 |
| 1 | 6528A | ASSEMBLY:UNIT FINAL III | 1 |